#### Work Order ID 61201



Page 1

Wednesday, August 11, 2010 10:08:25 AM Item ID: \_\_\_\_\_ D3537-1 Accept Setup Start **Revision ID:** Stop Item Name: Wearpad **Start Qty: 50.00** Start Date: 8/11/2010 Cust Item ID: Req'd Oty: 50.00 Required Date: 8/25/2010 **Customer:** Reference: Run Start Process Plan: \_\_\_\_MF Date: 10-8-11 Tooling: Approvals: Date: \_\_\_\_\_\_ Stop OC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Reject Tool ID Tool # Plan Accept Reject Insp. Work Center ID Description Qty Qty **Run Hours** Code Number Stamp **Draw Nbr Revision Nbr** D3537 Rev C 100 0.00 FLOW WATER JET B10-8-18 Waterjet 0.00 Memo C □Prog Rev: C □2-Deburr FLOW CNC Waterjet 1-Cut as per Dwg D3537 Dwg Rev: if necessary 500, HOE 110 QC2- Inspect parts off machine FAI/FAIB 0.00 B10-8-18 0.00 Memo Quality Control 120 QC8- Inspect parts - second check 0.00 0.00 Memo Quality Control

W/O:			W	ORK ORDER CHA	NGES					
DATE	STEP	PRO	CEDURE CH	ANGE		Ву	Date C	<b>⊋ty</b> ∣ Chief	roval Eng / I Mgr	Approval QC Inspector
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Part No		PAR #:			NCF	R: Yes N	lo <b>DQA</b> :	D	ate: _	
	Re	esolution:	Dispositi	on:	QA:	N/C Clo	sed:	D	ate:	
NCR:	`	1	WORK OR	DER NON-CONFOR	RMANCE	(NCR)	)			
DATE	STEP	Description of NC	Initial	Corrective Action Action Descripti	Section B	Sign &	Verificat		roval	Approval
<u> </u>		Section A	Chief Eng	Chief Eng		Date	Section	C Chie	ef Eng	QC Inspector
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## Work Order ID 61201

Required Date: 8/25/2010

Page 2

Wednesday, August 11, 2010 10:08:25 AM

Item ID: **Revision ID:**  D3537-1

Accept

Setup Start

Stop



Item Name: **Start Date:** 

8/11/2010

Wearpad

**Start Qty: 50.00** Req'd Qty: 50.00

**Cust Item ID:** 

**Customer:** 

Tool ID

Reference:

Approvals:

Process Plan: Date: Tooling:

Date:

Start Run



QC: \_\_\_\_ Date:

SPC (Y/N):

Date:

Code

Tool # Plan

Accept Qty

Reject Qty

Stop

Reject Insp. Number Stamp

Sequence ID/ Work Center ID

130

Brake NC

Brake NC

Operation Description

NC BRAKE

Set Up/ **Run Hours** 

0.00

0.00

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. □2-

Identify as D3537-1

0.00

Large Fab

140

Large Fab

Memo

Memo

0.00

Large Fab

Description Batch□A/R

2059B Hardcoat □1-Weld as per Dwg D3537 using Jig DT 8210□2-Remove any

weld that penetrated through Wearpadif necessary

150

QC10- Inspect visual per QSI004- ground welds

0.00

500/06/31

0.00

A- 10-8-31



Quality Control

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W/O:			WC	RK ORDER CHANGE	S				
DATE	STEP	PRO	CEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No <b>DQ</b>	A:	Date: _	
	R	esolution:	Dispositio	າ:	QA: N/C CI	osed:		Date: _	<u>.</u>
NCR:		\	WORK ORDI	ER NON-CONFORMA	NCE (NCF	3)			
	T	Description of NC		Corrective Action Section		Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		ion C	Chief Eng	QC Inspector
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Work	Oro	ler i	ID (	61	20	1



Page 3

Wednesday, August 11, 2010 10:08:25 AM

Item ID:

D3537-1

Accept



Setup Start

Stop



**Revision ID:** 

**Start Date:** 

Item Name:

Wearpad

8/11/2010

**Start Qty: 50.00** Req'd Qty: 50.00

**Cust Item ID:** 

**Customer:** 

Reference:

**Approvals:** 

Process Plan:

Date: Tooling:

Date:

Start Run



Required Date: 8/25/2010

Date:

SPC (Y/N):

Set Up/

**Run Hours** 

Date:

Stop

Reject

Insp.

Sequence ID/ **Work Center ID** 

160

OC

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

0.00

**Tool ID** 

Tool # Plan Accept Qty Code

Qty

Reject Number Stamp

170

Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

0.00

Memo START TIME:

Memo

Memo

□OVEN TEMPERATURE:

320' \_DFINISH TIME:

\_9*x*00\_

180

Quality Control

QC3- Inspect Part Finish

10/09/01

x60\_9/\_\_\_\_

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W/O:			WO	RK ORDER CHANGI	ES				
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Categ	jory:	NCR: Yes	No <b>DQ</b>	A:	_ Date: _	
	R	esolution:	Disposition	):	QA: N/C C	losed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCI	₹)			•
DATE	CTED	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	ion C	Chief Eng	QC Inspector
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#### Work Order ID 61201

Page 4

Wednesday, August 11, 2010 10:08:25 AM

Item ID:

D3537-1

**Revision ID:** 

**Item Name:** Wearpad

**Start Date:** 

8/11/2010

**Start Qty: 50.00** 

Req'd Qty: 50.00 Required Date: 8/25/2010

Accept

Setup Start

Stop

**Cust Item ID:** 

**Customer:** 

Tool ID

Reference:

Approvals:

Process Plan:

QC: \_\_\_\_

Date:

Tooling: Date:

SPC (Y/N):

Set Up/

0.00

0.00

Run Hours

Date: Date: Start

Reject

Qty

Run

Stop

Reject

Number

Insp.

Stamp

Sequence ID/

Work Center ID

190

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location: P18

10/09/01

Tool # Plan

Code

Qty

Accept

200

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

Memo

0.00

- islog/027}-mx 10-9-01

W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:	Fault Ca	tegory:	_ NCR: Yes	No <b>DG</b>	A:	Date: _	
	R	esolution:	Disposit	on:	_ QA: N/C CI	osed:		Date: _	
NCR:		V	WORK OR	DER NON-CONFORMA	ANCE (NCR	1)			
DATE	STEP	Description of NC			ion B		ication	Approval	Approval
DAIL	SILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sec	tion C	Chief Eng	QC Inspector
1:									

## **Picklist Print**

Wednesday, August 11, 2010 10:08:25 AM

Work Order ID: 61201

Parent Item: D3537-1

Parent Item Name: Wearpad



Start Date: 8/11/2010

Required Date: 8/25/2010

Page 1

Start Qty: 50.00

Required Qty: 50.00

Comments:

IPP Rev:A

New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA  304/316 Sheet .063		Purchased	No			100	sf	0.0267	0.106	5.578947	63 B10-8	-18	
*				Location	•	Loc	Ωtv	Loc Code					

 Location
 Loc Qty
 Loc Code

 MAT
 0.026694737

 111323
 0

 114799
 0.02669474

 II ► 44⊘

115440



	-								
W/O:			WO	RK ORDER CHANGE	S	• ·			
DATE	STEP	PRO	OCEDURE CHAN	GE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No DQA	<b>\:</b>	Date: _	<del> </del>
	Res	olution:	Disposition	:	QA: N/C CI	sed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR	)			
DATE	STEP	Description of NC		Corrective Action Section		Verific		Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	on C	Chief Eng	QC Inspector
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DART AEROSPACE LTD	Work Order:	61201
Description: Wearpad	Part Number:	D3537-1
Inspection Dwg: D3537 Rev: C		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

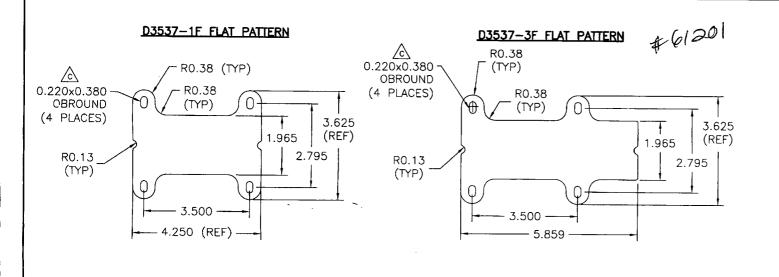
X	First Article		Prototype
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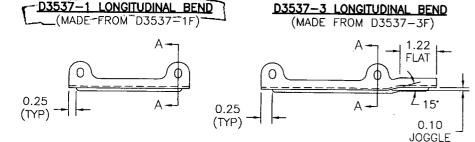
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.250	+/-0.010	५,७५१	<b>%</b>		V BOD	
3.500	+/-0.010	3.496	<b>Jec</b>		V	
1.965	+/-0.010	1.968	8		V	
2.795	+/-0.010	2791	>		V	
3.625	+/-0.010	3.633	æ		V	
0.220 x 0.380	+/-0.010	204 X-384	<b>&gt;</b>	_	V	
				7		

Measured by:	Audited by:	Prototype Approval:	N/A
Date: 10-8-18	Date: 1608.18	Date:	N/A

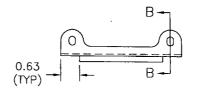
A         07.03.21         New Issue         KJ/JLM           B         07.04.27         Dimensions revised per Dwg Rev. B         KJ/JLM	Approved	Revised by	Date Change	Rev
B 07.04.27 Dimensions revised per Dwg Rev. B KJ/JLM		KJ/JLM	7.03.21 New Issue	A C
	1		7.04.27 Dimensions revised per Dwg Rev. B	В
C 07.05.28 Dimensions revised per Dwg Rev. C KJ/JLM	GH	KJ/JLM	7.05.28 Dimensions revised per Dwg Rev. C	C

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		WO	RK ORDER CHANG	ES				
STEP	PRO	OCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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STEP	Description of NC Section A	Corrective Action Section B			Verification		Approval	Approval
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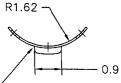




# (MADE FROM D3537-1F)

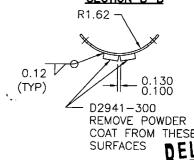


#### SECTION A-A

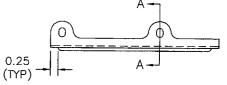


APPLY 2 LAYERS OF 2059B HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.188 TO 0.250 THICK

#### SECTION B-B



D3537-7 LONGITUDINAL BEND 962 (MADE FROM D3537-3F)



Α	06.11.06	NEW ISSUE
В	07.03.20	ADD AMS 5513 AND AMS 5524
С	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
	( , , , ,	

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07.04.13

	L <sub>R</sub>		07.03.20	ADD AMS 5513 AND AMS 5524	
	Α		06.11.06	NEW ISSUE	
C.	DESIG	CB	DRAWN BY	DART DART AEROSPACE US	, INC.
	CHECH	KED A	APPROVED A	DRAWING NO.	REV. C
:		4	4	D3537 SHEE	1 OF 1
	DATE			TILE	SCALE

WEARPAD

#### D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK) (REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

W/O:			WC	ORK ORDER CHANG	ES					
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
			·							
		,								
Part No:		PAR #:	Fault Cate	_ <b>NCR:</b> Yes I	No DQ	<b>4</b> :	Date:			
Resolution:			Disposition: Q		_ QA: N/C Cld	A: N/C Closed:			Date:	
NCR:		,	WORK ORD	ER NON-CONFORMA	NCE (NCR	)				
DATE	STEP	Description of NC Section A	Corrective Action Section			Verificati		n Approval	Approval	
DAIL			Initial Chief Eng	Action Description  Chief Eng	Sign & Date	Secti	on C	Chief Eng	QC Inspector	
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